

Work Order ID 130127

130127

Page 1

Tuesday, February 24, 2015 8:45:23 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1502-24 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

DAS
27
9-89

MLN MAY 05 2015

100 Document Control 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle: 89.8° DGC

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
05
9-89

MAY 07 2015

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							

110

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

15-3-9

DGL 15-3-9

PTO

DGL 15-3-10

BE 15-03-10

DQA:

Date:

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>130127</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-636-012</u>		Skid-tube ☒	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5063</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause ☒	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☒ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Stop ***NS2***

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Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: *M130812**70E15-03-10*

9- Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

① 15-03-10 *DAS*
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

① 15-03-10 *DAS*
9
9-89

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Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									



15-3-10

JDL 15-3-11

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 Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float holes using uni-bit to .500" (4 per Side)								
	4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5- Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7- Bond web D2739 in place as per OSI 015, let cure for 12hrs.								
	A/R Sikaflex-291 batch: <u>131574</u> exp. date: <u>15-10-21</u>								
	ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & OSI004 (welding instructions on sheet 9)								
	A/R Aluminum Rod batch: <u>M130812</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

DGL 15-3-11

DGL 15-3-11

78E15-03-12

D 15-3-13

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 Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- Spot face ground handling holes section (total of 4 places per side) as per
 dwg D2750

12- Deburr holes, ensure tube is free of all scratches before sending to
 paint.

Handwritten signature and date: 15-3-13

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Quality Control

Memo 0.00

Handwritten: 15-04-21 DAS 9 9-89

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC

Quality Control

Memo 0.00

VERIFY C'BOARD IS GOOD

Handwritten: 15-04-21 DAS 9 9-89

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
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Start Date: 2/24/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 1309922- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 132024

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

DAS
15
9-89

1 15-4-22
1 15-0425
1137 d 156 15

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Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11131574</u>								
	EXP DATE: <u>15110</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11131349</u> RTU 598 M132017 <u>ex 11563</u>								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>11229a</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
38
0-89

MAY 01 2015

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Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00				DAS 27 5-89			
250									
Packaging	Memo	0.00						DAS 28 9-89	
Packaging						MAY 05 2015			
260	QC4- 100% Inspect kits for completeness	0.00				DAS 66 9-89			
260									
QC	Memo	0.00							
Quality Control									MAY 07 2015
270	Packaging	0.00							
270									
Packaging	Memo	0.00						DAS 6 9-89	
Packaging	Package as per PPP D350-636-012					MAY 14 2015			

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Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21 - Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ MAY 15 2015

MLJ MAY 15 2015

Picklist Print

Tuesday, February 24, 2015 8:45:27 AM

Work Order ID: 130127

130127

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

62.0000

8

8

D2743

Crossbolt Spacer

BE 15-03-12

B129465 *8

Location

Loc Qty

Loc Code

LG001

62

128943

62

D3490-3

Manufactured No

160

Each

43.0000

4

4

D3490-3

Cross Bolt Spacer

BE 15-03-12

Location

Loc Qty

Loc Code

LG001

43

129055

43

D3490-1

Manufactured No

160

Each

45.0000

4

4

D3490-1

Cross Bolt Spacer

BE 15-03-12

Location

Loc Qty

Loc Code

LG001

45

128984

45

D3631-1

Manufactured No

230

Each

182.0000

8

8

D3631-1

Washer

all 15/04/25

Location

Loc Qty

Loc Code

FP001

182

128320

82

128910

100

11131 626

x 8

Picklist Print

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D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 30.0000 1 1

D3791-1

Wearpad

**

all 15/04/20

Location

Loc Qty

Loc Code

FP002

30

125913

11

126317

19

✓1

D3793-3 Manufactured No 230 Each 25.0000 1 1

D3793-3

Wearplate Aft

**

all 15/04/20

Location

Loc Qty

Loc Code

FP002

25

125915

11

128236

14

13130534

✓1

MS21043-6 Purchased No 230 Each 170.0000 4 4

MS21043-6

NUT

**

all 15/04/20

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

50

m130325

2

m130726

48

ST304

100

131618

100

11132161

✓1

Picklist Print

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Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No 230 Each 32.0000 1 1

D3794-1

Gasket Fwd

ll 5/10/12

Location

Loc Qty

Loc Code

FP001

32

125916

6

128238

26

NAS1611-010

Purchased No

230 Each

300.0000

8

8

NAS1611-010

O-RING

ll 5/10/12

Location

Loc Qty

Loc Code

FP001

300

m130797

4

m131329

96

m131618

200

M130770

yo

D2741

Manufactured No

250 Each

11.0000

1

1

D2741

Replacement Blade

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

125892

1

B124048

*DAS
MAY 27 2015*

*DAS
28
9-89*

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Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

539.0000

4

4

***NAS1515H3I ***

Washer

**

all 15104128

Location

Loc Qty

Loc Code

FG	40	
102472	40	
FP001	55	
m127831	55	
ST266	444	
m127831	48	
m130726	396	

XD

NAS1611-013

Purchased

No

230

Each

678.0000

8

8

NAS1611-013

O-RING

**

all 15104128

Location

Loc Qty

Loc Code

FP001	678	
m130758	678	

vg

AN3C6A

Purchased

No

230

Each

440.0000

4

4

AN3C6A

Bolt

**

all 15104128

Location

Loc Qty

Loc Code

CA	39	
m128704	39	
FG	10	
122416	10	
ST338a	391	
m128769	391	

vd

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Shop Packet Print

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Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

152.0000

1

1

NAS1149C0832R

Washer

all 15/04/28

Location

Loc Qty

Loc Code

FP001

8

m114915

8

ST271

144

m125807

144

D3536-25

Manufactured

No

230

Each

18.0000

1

1

D3536-25

Gasket Center

all 15/04/28

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

12

125909

1

128578

11

D3794-3

Manufactured

No

230

Each

68.0000

1

1

D3794-3

Gasket Aft

all 15/04/28

Location

Loc Qty

Loc Code

FP001

68

125917

4

127383

39

128239

24

92658

1

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Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

953.0000

34

34

AN3C5A

Bolt

all 1310d28

Location

Loc Qty

Loc Code

FG

5

122800

5

11131803

ST338a

526

x34

M130770

10

M130851

16

M131320

500

ST350

422

M131420

422

D3537-1

Manufactured

No

230

Each

139.0000

3

3

D3537-1

Wearpad

all 1510d28

Location

Loc Qty

Loc Code

FG

18

79833

8

1313158

88562

10

x3

FP001

121

125911

46

126306

1

127087

60

128225

14

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Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

66.0000

1

1

D3535-25

Wearplate Center

all 15/04/25

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

56

125908

15

128090

16

128224

25

FP007

8

127851

8

D3492-3

Manufactured No

230

Each

245.0000

8

8

D3492-3

Plug

all 15/04/25

Location

Loc Qty

Loc Code

FP001

245

125905

2

128476

72

128914

171

B131036

x 2

Picklist Print

Tuesday, February 24, 2015 8:45:27 AM

Page 9

Work Order ID: 130127

130127

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,324.000

38

38

NAS1149C0332R

WASHER

lll 2/24/25

Location

Loc Qty

Loc Code

FP001

2155

m130325

2140

m130466

15

GA

2

125654

2

ST271

3167

125654

44

m131340

1123

m131618

2000

D3488-042

Manufactured

No

230

Each

7.0000

1

1

D3488-042

Blade Fitting RH

lll 2/24/25

Location

Loc Qty

Loc Code

FP001

7

125899

7

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

2,586.000

38

38

ALS4-1032-225

Rivnut

lll 2/24/25

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

41

M131067

41

st549

2425

M131582

2425

V38

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Page 10

Work Order ID: 130127

130127

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No

230 Each 277.0000 8 8

D3492-1

Plug

**

all welded

Location

Loc Qty

Loc Code

FP001

277

B13113

x8

128509

156

128955

121

D3793-1 Manufactured No

230 Each 28.0000 1 1

D3793-1

Wearplate Fwd

**

all welded

Location

Loc Qty

Loc Code

FP002

28

125914

18

x1

128235

10

AN8C35A Purchased No

230 Each 5.0000 1 1

AN8C35A

Bolt

**

all welded

Location

Loc Qty

Loc Code

FG

5

M131947

121275

5

x1

MS21083C8 Purchased No

230 Each 135.0000 1 1

MS21083C8

Nut

**

all welded

Location

Loc Qty

Loc Code

ST299

100

m131618

100

x1

ST300

35

m131049

35

Picklist Print

Tuesday, February 24, 2015 8:45:27 AM

Work Order ID: 130127

130127

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 199.0000 8 8

D2745

Bushing

ll 2/26/25

Location

Loc Qty

Loc Code

FP001
128920
ST010
128480
ST012a
128089

18
18
100
100
81
81

B129584

28

AN6C44A Purchased No 230 Each 146.0000 4 4

AN6C44A

Bolt

ll 2/26/25

Location

Loc Qty

Loc Code

FG
103964
FP001
m130863
m131367
ST286A
m130863
ST332
m130863
ST333
m131151
m131546

2
2
5
4
1
13
13
11
11
115
50
65

11131856

24

Picklist Print

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Page 12

Work Order ID: 130127

130127

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3532-1 Manufactured No 250 Each 42.0000 2 2

D3532-1

Spacer

DAS

27

9-89

DAS

28

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST048

42

B131/32

2

125907

2

128091

40

MS21083C8

Purchased No

250 Each

135.0000

2

2

MS21083C8

Nut

DAS

27

9-89

Location

Loc Qty

Loc Code

ST299

100

m131618

100

M132067

2

ST300

35

m131049

35

NAS1149D0863J

Purchased No

250 Each

718.0000

2

2

NAS1149D0863J

Washer

DAS

27

MAY 15 2015

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

661

125268

561

125635

100

DAS
28
9-89

DAS

28

9-89

Picklist Print

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Page 13

Work Order ID: 130127

130127

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

146.0000

2

2

D3493-1

Washer

DAS

27

9-89

Location

Loc Qty

Loc Code

FG

10

DAS

28

9-89

97201

10

ST046

136

125906

35

128755

101

2

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A

Purchased

No

250

Each

31.0000

2

2

AN8C21A

Bolt

DAS

27

9-89

MAY 05 2015

Location

Loc Qty

Loc Code

FG

2

DAS

28

9-89

123966

2

ST332

29

m131100

3

m131547

26

m132169

2

DAS

28

9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALDINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

130127 MCT

1502-24

RELEASED
2013-08-13

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS, INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN	B		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

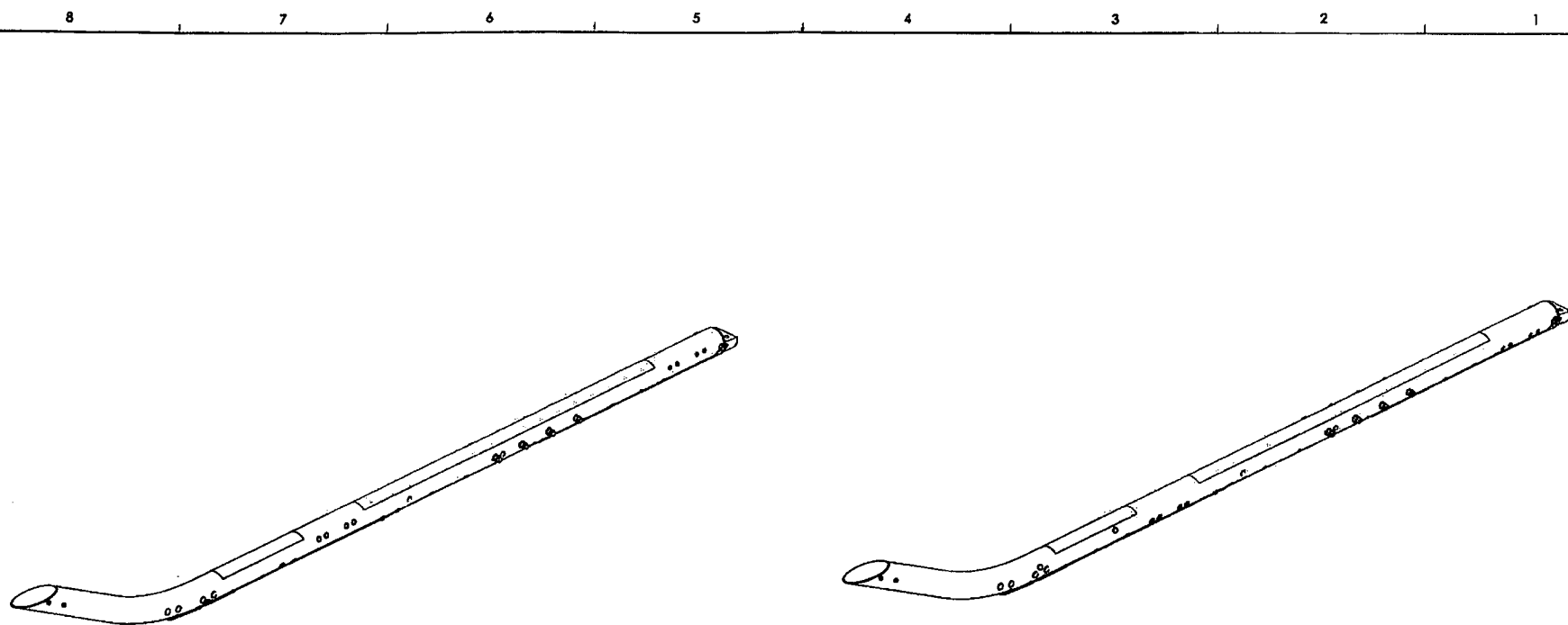
TITLE

350 SKIDTUBE ASSEMBLY

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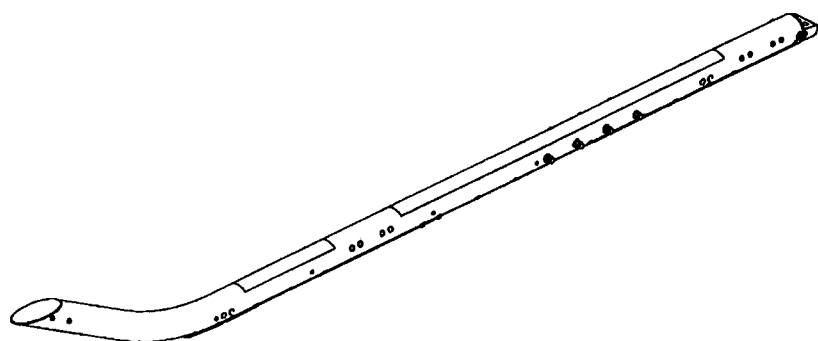


D2750-041 350 SKIDTUBE ASSEMBLY, LH

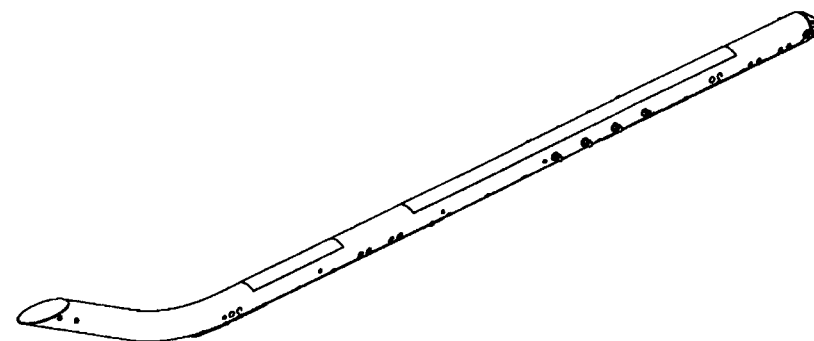
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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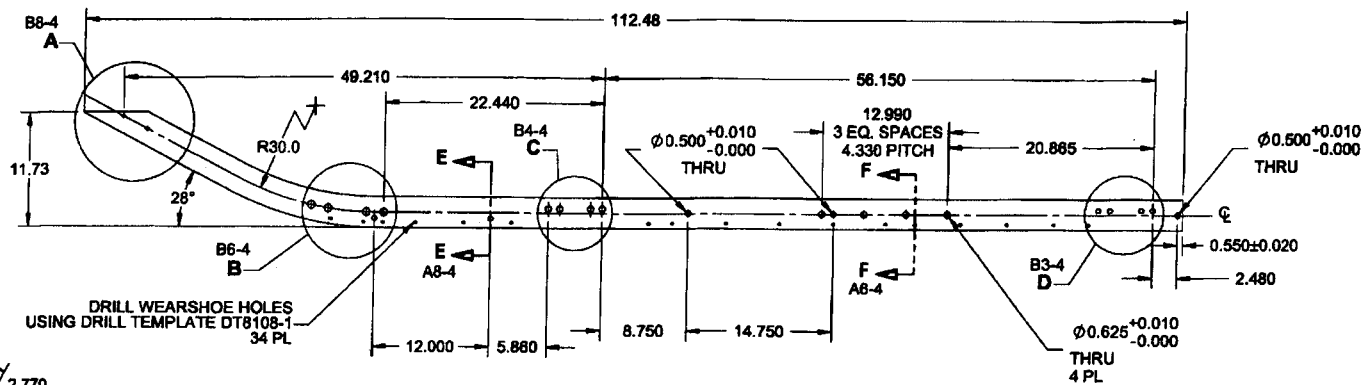
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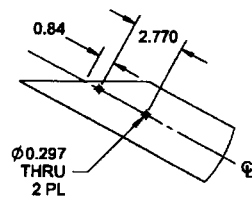
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13

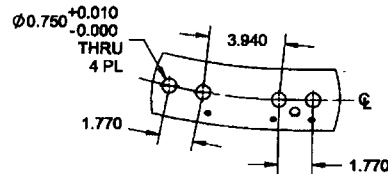
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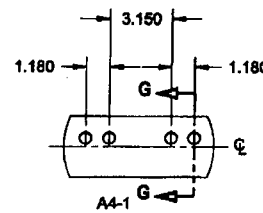
D2750-1 LH SKIDTUBE



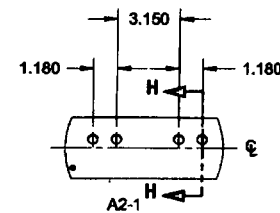
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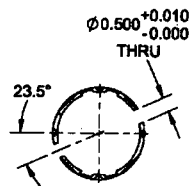
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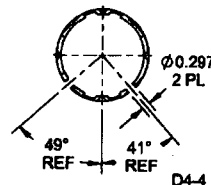
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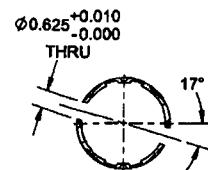
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SCALE 2X



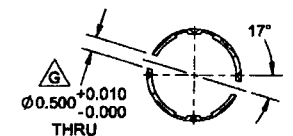
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

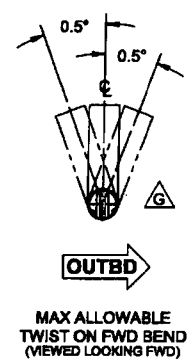
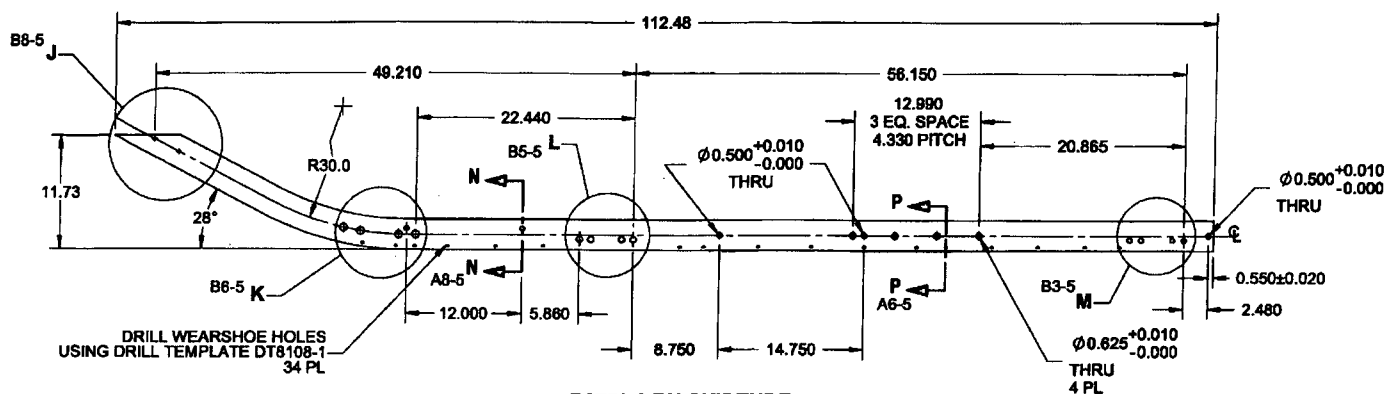


SECTION H-H
SCALE 3X, 4 PL

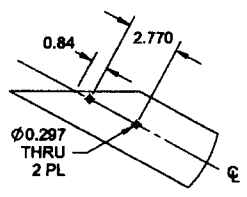
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DATE	13.07.11

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D2750	SHEET 4 OF 11
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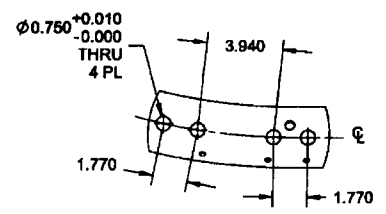
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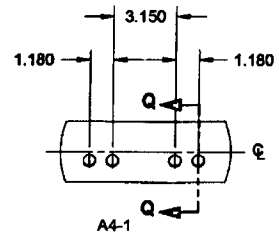
D2750-2 RH SKIDTUBE



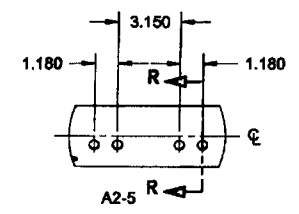
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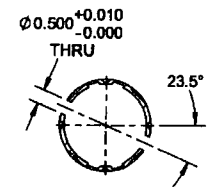
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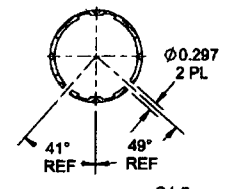
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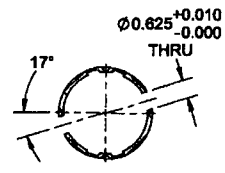
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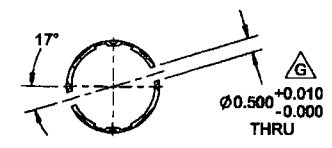
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

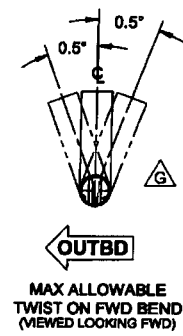
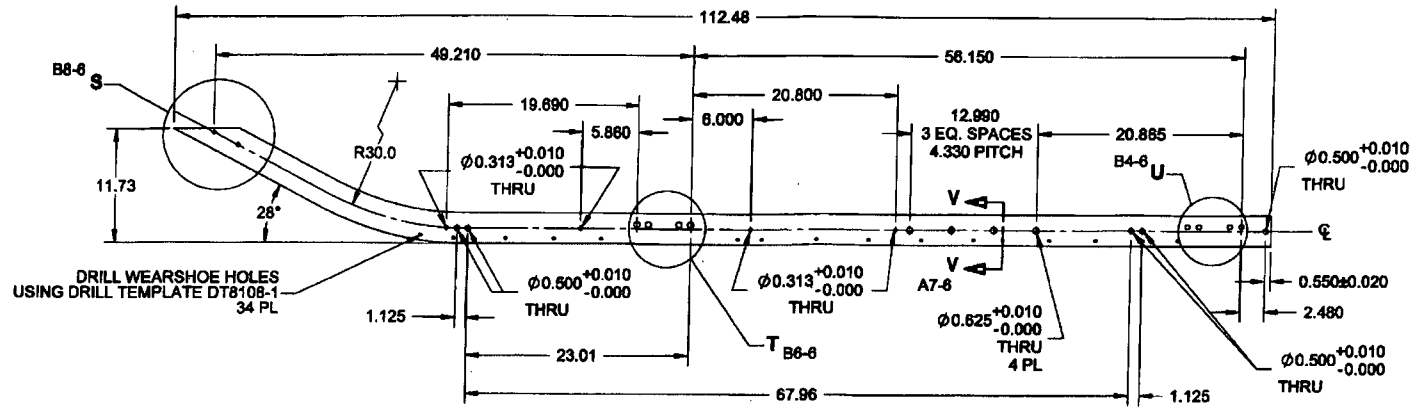


SECTION R-R
SCALE 3X, 4 PL

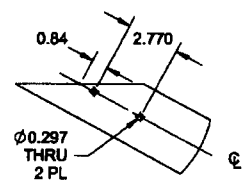
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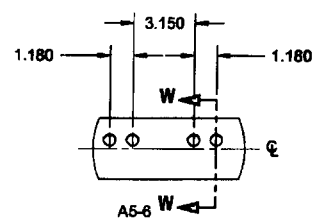
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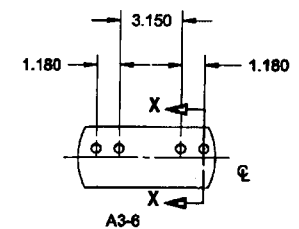
D2750-3 LH SKIDTUBE



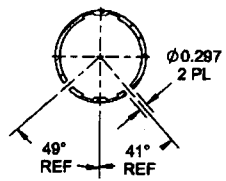
DETAIL S
D8-6
SCALE 2X



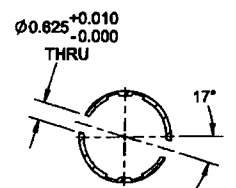
DETAIL T
C5-6
SCALE 2X



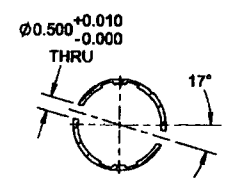
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL

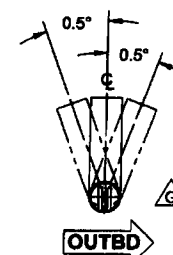
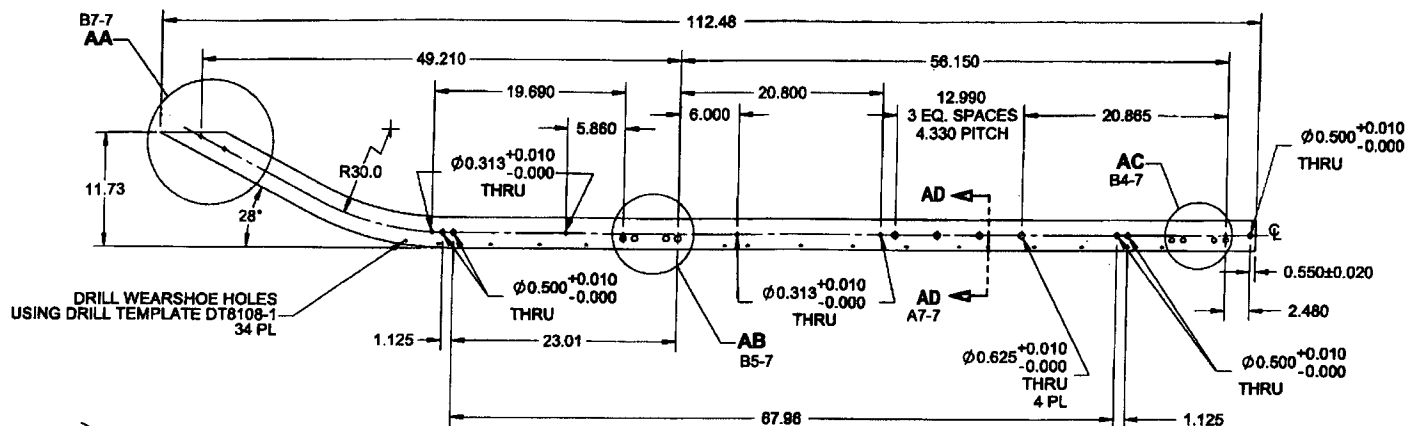


SECTION X-X
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SCALE 3X, 4 PL

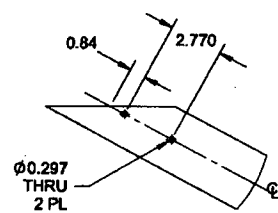
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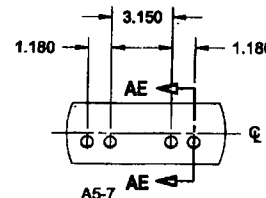
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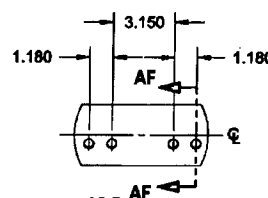
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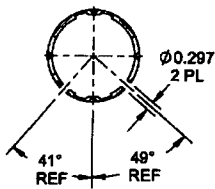
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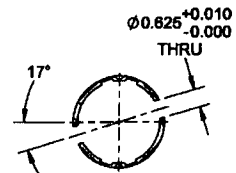
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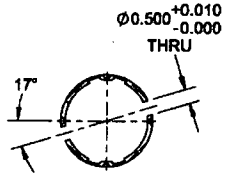
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SECTION AD-AD
D3-7
SCALE 3X, 17 PL



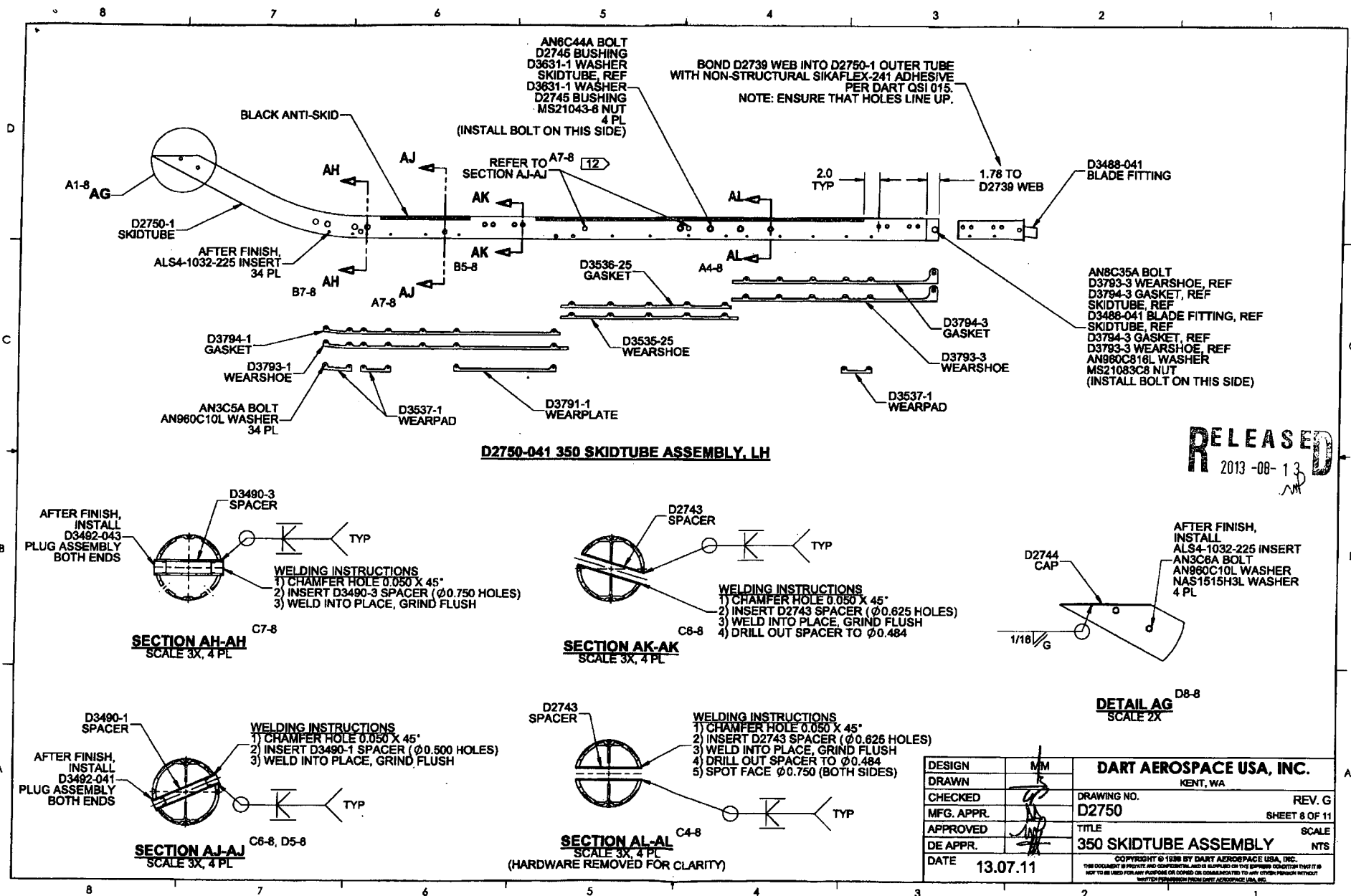
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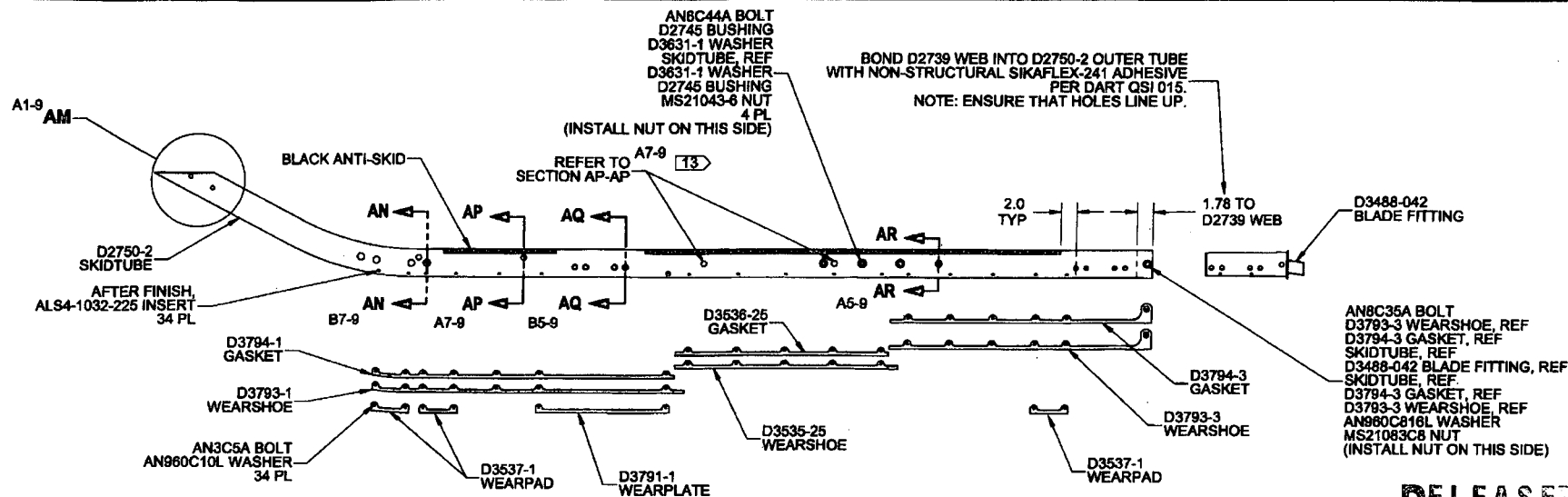
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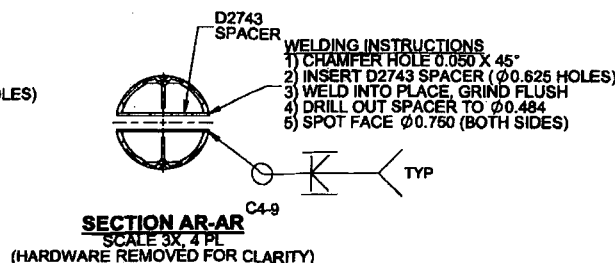
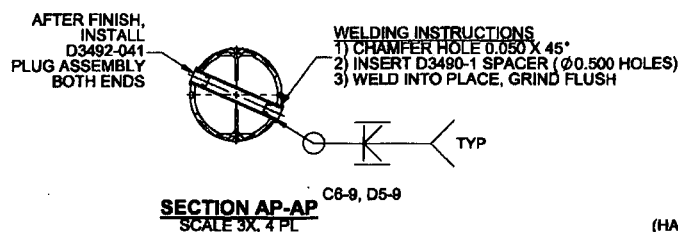
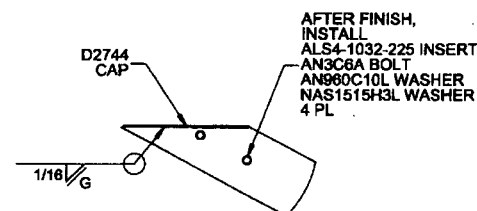
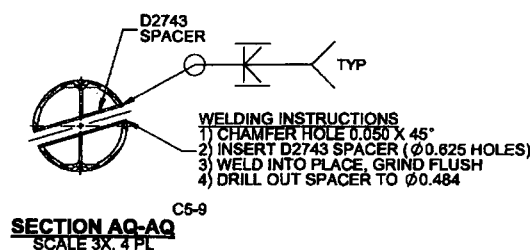
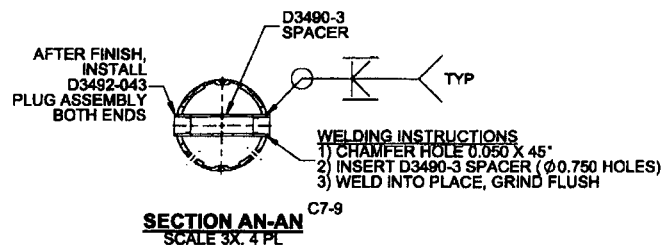


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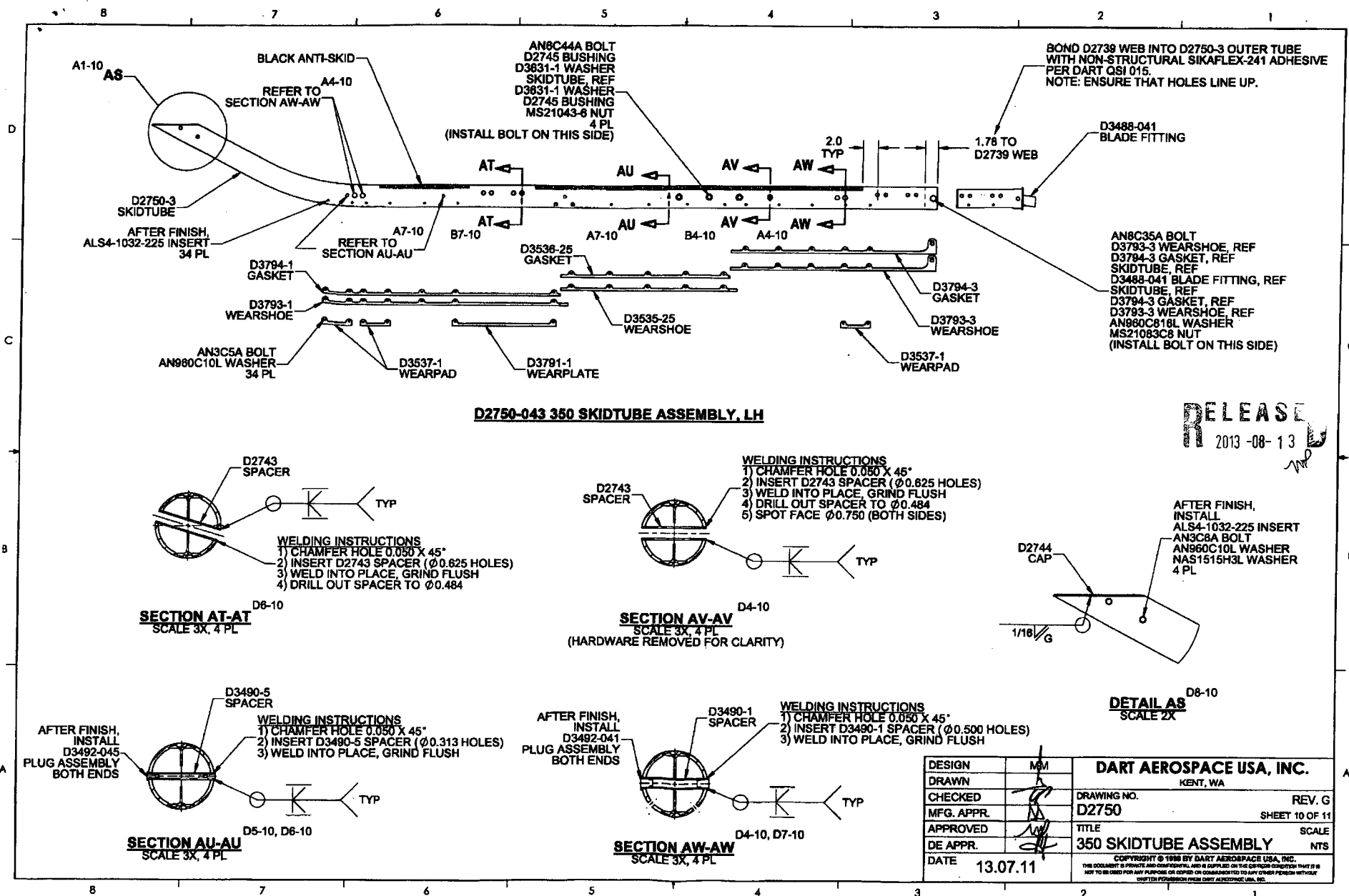


D2750-042 350 SKIDTUBE ASSEMBLY, RH

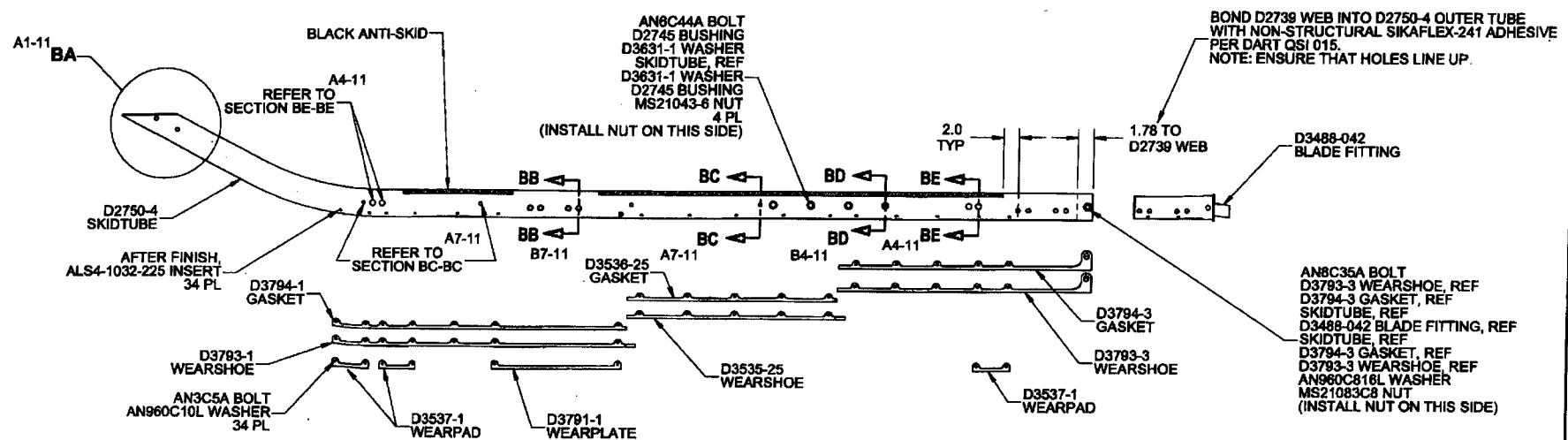
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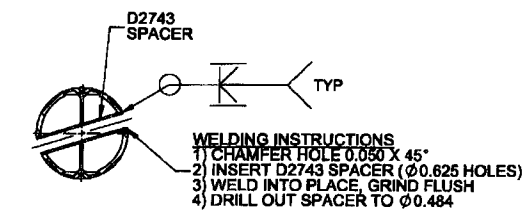
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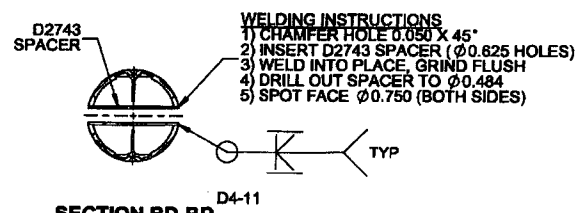
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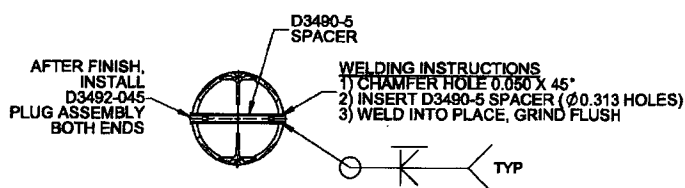
D2750-044 350 SKIDTUBE ASSEMBLY, RH



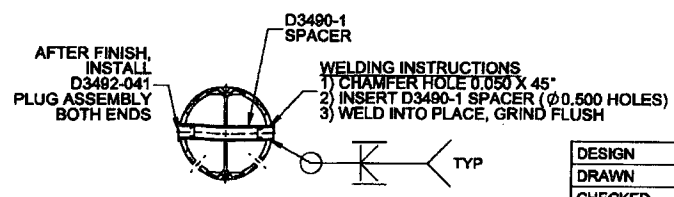
SECTION BB-BB
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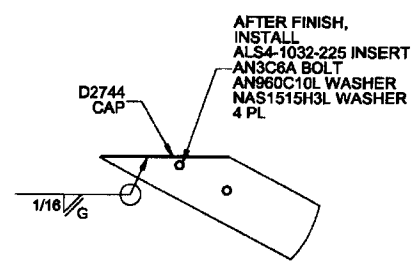
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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8 7 6 5 4 3 2 1